Work Order ID 70641

Monday, June 20, 2011 8:15:06 AM

Item ID: D412-742-013 **Accept** **Setup Start**

Revision ID:

Item Name: Float Skidtube Installation **Stop**

Start Date: 6/10/2011 **Start Qty:** 1.00 **Cust Item ID:** DUPLICATE

Required Date: 6/30/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 11-06-20 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
IIN D412-742 / D									
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-742-013 CHG006								
110	Pick Kit	0.00							
Packaging	**Memo**	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
QC	**Memo**	0.00							
Quality Control									

for BG 11-6-20

11/6/20

11/6/20

Work Order ID 70641

Monday, June 20, 2011 8:15:06 AM

Item ID: D412-742-013 **Accept** **Setup Start**

Revision ID:

Item Name: Float Skidtube Installation **Stop**

Start Date: 6/10/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 6/30/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Packaging	Packaging								
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-013 Location:_____								
	NEW								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

11/6/30

11/06/30

Picklist Print

Monday, June 20, 2011 8:15:01 AM

10

Work Order ID: 70641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 6/10/2011 **Required Date:** 6/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev: A□05.10.13□New Issue□ KJ/JLM□
IPP Rev:B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN 1072 DD verified by:JLM
IPP Rev:D 08-09-08 ecn 08-510 DD verified by:EC
IPP Rev:E 09-01-23 as per DSI9441 DD verified by:EC IPP RevF: add AN4C7A DD 10.01.13 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C7A Bolt		Purchased	No			110	Each	367.0000	4	4			
				Location		**Loc Qty**		**Loc Code**					
				ST356		367							
					109147	367				4			
D412-742-043 Replacement Float Skidtube		Manufactured	No			110	Each	0.0000	1	1	70643		
D2571 Saddle, Fwd Out 205		Manufactured	No			110	Each	4.0000	1	1			
				Location		**Loc Qty**		**Loc Code**					
				ST434		4							
					69698	4							
D2572 Saddle, Fwd In 205		Manufactured	No			110	Each	1.0000	1	1	B70457		
				Location		**Loc Qty**		**Loc Code**					
				ST434		1							
					69336	1							

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 8:15:02 AM

Work Order ID: 70641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 6/10/2011 **Required Date:** 6/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2573 Saddle, Aft Out 205	Manufactured	No	110	Each	2.0000	1	1	B70458

Location	Loc Qty	Loc Code
ST434	2	
69697	2	

D2574 Saddle, Aft In 205	Manufactured	No	110	Each	2.0000	1	1	B70459 11/6/22

Location	Loc Qty	Loc Code
ST434	2	
69699	2	

D2876 Saddle Spacer	Manufactured	No	110	Each	52.0000	2	2	

Location	Loc Qty	Loc Code
ST025	16	
66849	16	
ST026	36	
68282	36	

D2877 Saddle Spacer	Manufactured	No	110	Each	71.0000	2	2	11/6/15

Location	Loc Qty	Loc Code
ST025	71	
66843	21	
68283	50	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Monday, June 20, 2011 8:15:02 AM

Work Order ID: 70641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 6/10/2011 **Required Date:** 6/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3403-1 Bushing	Manufactured	No	110	Each	77.0000	16	16	

Location	Loc Qty	Loc Code
ST052	77	
69508	37	
70696	40	

D2747 Set Screw	Manufactured	No	110	Each	130.0000	4	4	

Location	Loc Qty	Loc Code
ST021	130	
64276	30	
69494	100	

D3533-1 Set Screw	Manufactured	No	110	Each	86.0000	2	2	11/6/21

Location	Loc Qty	Loc Code
ST066	86	
67583	86	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 8:15:02 AM

Work Order ID: 70641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 6/10/2011 **Required Date:** 6/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN4C6A Bolt	Purchased	No	110	Each	340.0000	16	16	

Location		Loc Qty	Loc Code
FG		4	
	103344	4	
ST306		44	
	117313	44	16
ST356		292	
	116704	17	
	117619	150	
	117794	50	
	117872	75	

AN4C52A BOLT	Purchased	No	110	Each	107.0000	8	8	

Location		Loc Qty	Loc Code
ST361		107	
	117163	60	
	117619	8	
	117688	14	7
	118012	25	

AN6C12A BOLT	Purchased	No	110	Each	62.0000	8	8	11/6/2-8

Location		Loc Qty	Loc Code
ST342		62	
	116022	8	
	117688	54	8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Monday, June 20, 2011 8:15:02 AM

Work Order ID: 70641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 6/10/2011 **Required Date:** 6/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3672-3 Phenolic Washer	Manufactured	No		110	Each	359.0000	32	32	

Location	Loc Qty	Loc Code
ST074	359	
64176	359	

32

AN960C416L WASHER	Purchased	No		110	Each	0.0000	32	32	M117291
D3672-9 Phenolic Washer	Manufactured	No		110	Each	328.0000	8	8	

Location	Loc Qty	Loc Code
ST074	328	
35523	328	

8

AN960C616L WASHER	Purchased	No	MAS1149C0632R	110	Each	4.0000	8	8	M11800

Location	Loc Qty	Loc Code
ST347	4	
113064	4	

D3672-11 Phenolic Washer	Manufactured	No		110	Each	411.0000	16	16	11/6/21

Location	Loc Qty	Loc Code
ST074	411	
58046	411	

16

Picklist Print

Monday, June 20, 2011 8:15:02 AM

Work Order ID: 70641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 6/10/2011 **Required Date:** 6/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS21043-4 Nut	Purchased	No	110	Each	1,111.000	29	29	

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST300	71	
117423	71	
ST301	1000	
117601	500	
117793	500	

D3403-3 Bushing	Manufactured	No	110	Each	61.0000	8	8	

Location	Loc Qty	Loc Code
ST	61	
69509	61	

D3405-041 Lug Assembly	Manufactured	No	110	Each	2.0000	1	1	B68970 1/16/21

Location	Loc Qty	Loc Code
ST474	2	
62227	2	

D3405-043 Lug Assembly	Manufactured	No	110	Each	6.0000	1	1	68966 1/4/28

Location	Loc Qty	Loc Code
ST423	2	
65703	2	
ST474	4	
68343	4	

Picklist Print

Monday, June 20, 2011 8:15:02 AM

Work Order ID: 70641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 6/10/2011 **Required Date:** 6/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN4C47A Bolt	Purchased	No		110	Each	55.0000	4	4

Location	Loc Qty	Loc Code
ST361	55	
117163	40	
117619	15	

D3407-041 Tow Ring	Manufactured	No		110	Each	0.0000	1	1 B69885
D3417-3 Washer	Manufactured	No		110	Each	84.0000	2	2

Location	Loc Qty	Loc Code
FG	9	
33519	9	
ST053	75	
51648	28	
53182	23	
66847	24	

D3456-1 Washer	Manufactured	No		110	Each	48.0000	1	1 11/6/21

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST054	41	
66848	3	
69774	38	

Picklist Print

Monday, June 20, 2011 8:15:03 AM

Work Order ID: 70641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 6/10/2011 **Required Date:** 6/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN3C37A BOLT	Purchased	No	110	Each	125.0000	1	1	

Location		Loc Qty	Loc Code
ST353		98	
	116874	11	
	117010	2	
	117763	25	
	117885	60	
ST354		27	
	117343	27	

AN3C40A BOLT	Purchased	No	110	Each	87.0000	1	1	

Location		Loc Qty	Loc Code
ST354		87	
	112454	37	
	114442	50	

AN3C41A BOLT	Purchased	No	110	Each	161.0000	1	1	11/6/21

Location		Loc Qty	Loc Code
FG		4	
	103324	4	
ST354		157	
	117163	2	
	117407	80	
	117950	75	

Picklist Print

Monday, June 20, 2011 8:15:03 AM

Work Order ID: 70641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 6/10/2011 **Required Date:** 6/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN3C42A BOLT		Purchased	No	110	Each	43.0000	1	1	

Location	Loc Qty	Loc Code
ST354	43	
106176	23	
117763	20	

AN3C43A BOLT		Purchased	No	110	Each	59.0000	4	4	

Location	Loc Qty	Loc Code
ST354	34	
114455	20	
117313	14	
ST355	25	
117688	25	

AN3C46A BOLT		Purchased	No	110	Each	42.0000	5	5	

Location	Loc Qty	Loc Code
FP-B	17	
113302	17	
ST355	25	
117764	25	

AN960C10L washer	NAS1149C0332R	Purchased	No	110	Each	0.0000	26	26	M117126 11/6/2018

Picklist Print

Monday, June 20, 2011 8:15:03 AM

Work Order ID: 70641

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 6/10/2011 **Required Date:** 6/30/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS21043-3	Purchased	No	110	Each	247.0000	13	13	11/6/2
Nut								

Location		Loc Qty	Loc Code	
FG		72		
	103691	72		
ST301		175		
	112314	175		13

5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -013	Qty -043	Part Number	Description
	X		**D412-742-013**	**FLOAT SKIDTUBE INSTALLATION**
	1	X	**D412-742-043**	**FLOAT SKIDTUBE**
		1	**D3391-043**	**412 FLOAT SKIDTUBE**
1		*24	*AN3C4A	*BOLT
3		*12	*AN3C6A	*BOLT
4		*8	*AN3C7A	*BOLT
5		*44	*AN960C10L	*WASHER
21A		*1	*D3564-1	*WEARSHOE (REPLACES D3460-1)
21B		*1	*D3566-1	*GASKET
22A		*1	*D3564-3	*WEARSHOE (REPLACES D3460-3)
22B		*1	*D3566-1	*GASKET
23A		*1	*D3564-5	*WEARSHOE (REPLACES D2577-5)
23B		*1	*D3566-5	*GASKET
10		***1**	***D3391-021**	***412 FORWARD TUBE**
11		**1	**D3401-041	**TOW CAP
12A		**10	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
12B		**2	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB166)
13		**10	**AN3C4A	**BOLT
14A		**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10	**AN960C10L	**WASHER
24A		**1	**D3564-13	**WEARSHOE
24B		**1	**D3566-13	**GASKET
20		***1**	***D3391-023**	***412 MID TUBE**
28		**20	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		***1**	***D3391-025**	***412 AFT TUBE**
25A		**1	*D3537-1	**WEARPAD
25B		**1	*D3553-1	**GASKET
26A		**1	*D3537-7	**WEARPAD
26B		**1	*D3553-3	**GASKET
31		**1	**D2646	**AFT CAP
32		**14	**AELS-1032-130	**INSERT
36		**12	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6	**AN3C4A	**BOLT
37B		**4	**AN3C5A	**BOLT
38A		**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10	**AN960C10L	**WASHER

(CONTINUED ON PAGE 19)

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(CONTINUED FROM PAGE 18)

Item	Qty -013	Qty -043	Part Number	Description
40	1		D2571	SADDLE, FWD OUTSIDE
41	1		D2572	SADDLE, FWD INSIDE
42	1		D2573	SADDLE, AFT OUTSIDE
43	1		D2574	SADDLE, AFT INSIDE
44	2		D2876	SADDLE SPACER
45	2		D2877	SADDLE SPACER
46	16		D3403-1	BUSHING
47A	4		D2747	SET SCREW
47B	2		D3533-1	SET SCREW
48	16		AN4C6A	BOLT
49	8		AN4C52A	BOLT
50	8		AN6C12A	BOLT
51A	32		D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32		AN960C416L	WASHER
52A	8		D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8		AN960C616L	WASHER
53	16		D3672-11	WASHER (REPLACES NAS1515H7L)
54	24		MS21043-4	NUT
55	4		ANC47A	BOLT
60	8		D3403-3	BUSHING
61	1		D3405-041	GHW LUG
62	1		D3405-043	GHW LUG
63	4		AN4C46A	BOLT
64	4		MS21043-4	NUT
70	1		D3407-041	TOW RING
71	2		D3417-3	WASHER
72	1		MS21043-4	NUT
73	1		D3456-1	WASHER
91	1		AN3C37A	BOLT
92	1		AN3C40A	BOLT
93	1		AN3C41A	BOLT
94	1		AN3C42A	BOLT
95	4		AN3C43A	BOLT
97	5		AN3C46A	BOLT
99	26		AN960C10L	WASHER
100	13		MS21043-3	NUT

*DENOTES PART IS INCLUDED WITH D3391-043 ASSEMBLY ABOVE
**DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3.
REF. FAA STC: SR01583SE
REF. CANADIAN STC: SH05-37
REF. EASA STC: EASA.IM.R.S.01126

INSTRUCTIONS: **REFERENCE ONLY**

1) FOR D412-742-011/-013 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, UPDATE THE PARTS LIST TO MODIFY THE BOLT USED TO ATTACH THE GHW LUG AS FOLLOWS:

5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List
32.15 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

ITEM	Qty -011	Qty -041	Qty -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

63	4			AN4C47A	BOLT

WAS:

63	4			AN4C46A	BOLT

5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List
32.16 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

ITEM	Qty -013	Qty 043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

63	4		AN4C47A	BOLT

WAS:

63	4		AN4C46A	BOLT

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	AJS	08.12.19

DESIGN	AJS	**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN	AJS	
CHECKED		DRAWING NO. DSI 9441 — REV. A — SHEET 1 OF 1
MFG. APPR.	N/A	
APPROVED		TITLE: BOLT CHANGE — SCALE: NTS
DE APPR.		
DATE	08.12.19	

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